

Date: Thursday, 20/11/2008 3:11:51 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RH ACTUATOR ASSEMBLY			
Job Number	: 43570						
Estimate Number	: 12770						
P.O. Number	:			Part Number	: 41232 200 001 002		
This Issue	: 20/11/2008	S.O. No. :			Drawing Number	: 41232-200-001 REV IR	
Prsht Rev.	: NC				Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB			
Previous Run	: 43287			Drawing Revision	: IR		
Written By	:			Material	:		
Checked & Approved By	: <u>JUL 08/11/21</u>			Due Date	: 28/12/2008		
Comment	: Est Rev:A New Issue 07-02-28 JLM			Qty:	4	Um: Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MS208224	elbow



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

elbow

Batch: M1103639/5/21SG

2.0	AN8424D	Elbow
-----	---------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Elbow

Batch: M1101399/5/21SG

3.0	41232 200 007 001	Brass Cylinder Assembly
-----	-------------------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Brass Cylinder Assembly

Batch: 451339/5/21SP

4.0	41232 200 003 001	Spring (Step Actuator)
-----	-------------------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spring (Step Actuator)

Batch: B309419/5/21SP

5.0	MS1699623	cap screw
-----	-----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

cap screw

Batch: M1039349/5/21SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:11:51 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 43570

Part Number: 41232 200 001 002

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M17566

9/5/21

SP

7.0 AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M111279

9/5/21

SP

8.0 AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M111279

9/5/21

SP

9.0 MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M110844

9/5/21

SP

10.0 AN322A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M106043

9/5/21

SP

11.0 41232 200 005 003

Spacer (Step Actuator)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spacer (Step Actuator)

Batch: B39218

9/5/21

SP

12.0 41232 200 002 005

pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pivot arm

Batch: 46701

9/5/21

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:11:51 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 43570

Part Number: 41232 200 001 002

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 41232 200 002 003

latch



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
latch
Batch: 46703 1X 3 8334 915121

SP

14.0 41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
tube
Batch: 43303

915121

SD

15.0 41232 200 008 001

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Decal
Batch: B46687

C 8/6/12

16.0 S 1455

spring-step actuator (replaces 71459)



(4x)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
spring-step actuator (replaces 71459)
Batch: M104079

915121

SC

17.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

FF 09-06-15

(5)

18.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8090615 44 RTI

(4)

19.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

946116

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:11:51 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 43570

Part Number: 41232 200 001 002

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 QC21

FINAL INSPECTION/W/O RELEASE



09/06/16 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JF
09-06-16

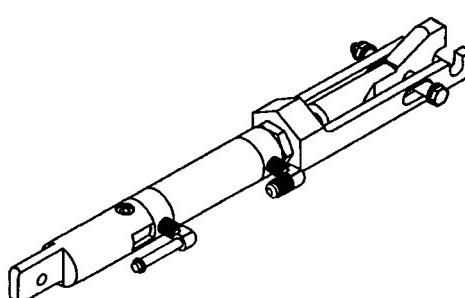
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

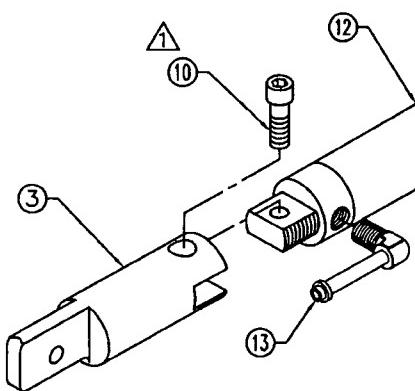
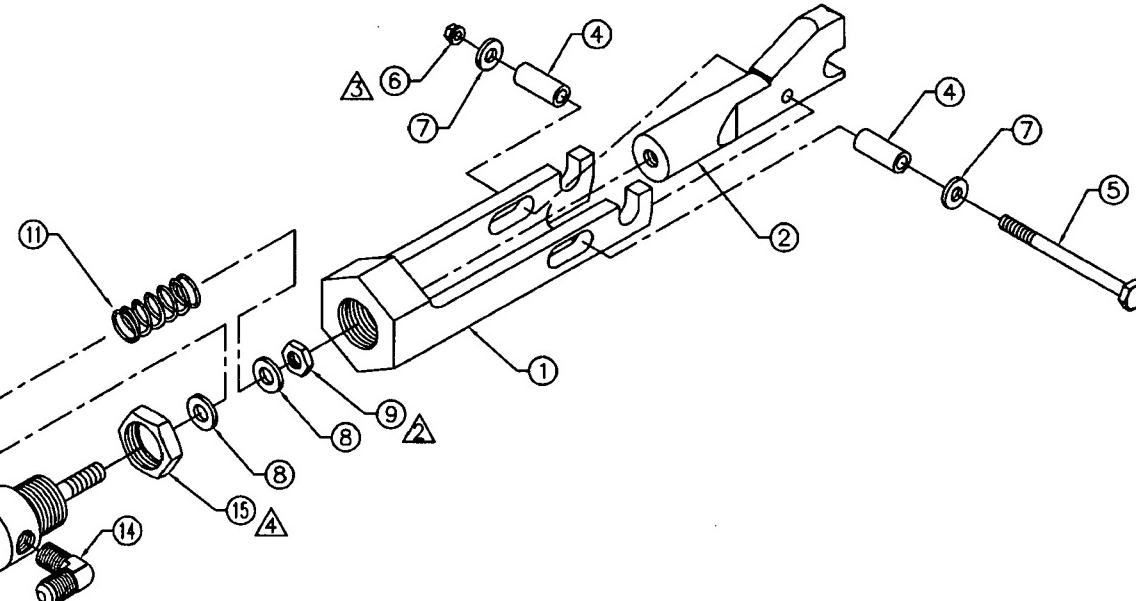
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

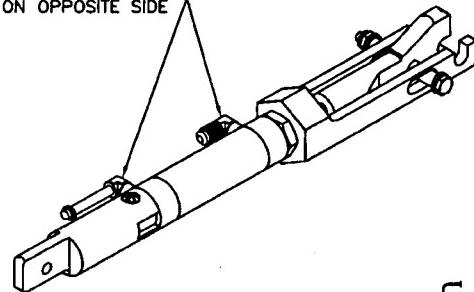
NOTE: Date & initial all entries



-001 L/H ACTUATOR ASSY



INSTALL ITEM #12
ON OPPOSITE SIDE



-002 R/H ACTUATOR

NSSY

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

SHOP COPY
RETURN TO
ENGINEERING
WORK ORDER
43570

- ⚠ TORQUE 80-100 IN.-LB.
- ⚠ TORQUE 20-25 IN.-LB.
- ⚠ TORQUE 50-75 IN.-LB.
- ⚠ TORQUE 50-75 IN.-LB.

NOTES:

NO. REQ'D PER ASSY	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE
LIST OF MATERIAL						
PROPRIETARY RIGHTS NOTICE		UNLESS OTHERWISE SPECIFIED	DRAFTSMAN D. NELSON 5/20/02	STRESS	TITLE STEP ACTUATOR ASSY	
THESE DATA ARE PROPRIETARY INFORMATION OF ERA AVIATION, INC. DISCLOSURE, REPRODUCTION, OR USE WITHOUT THE WRITTEN AUTHORIZATION FROM ERA AVIATION, INC., THE OWNER OF THE DATA, IS PROHIBITED. NOT APPLICABLE TO VENDOR PARTS.		X±.1 XX±.03 XXX±.010 ANGLES ±.1/2"	CHECK D. MURPHY 5/20/02	PROF ENGR	DWG. SIZE C	SCALE NONE
002-001	1 41232-000-001	NEXT ASSEMBLY	HEAT TREAT	FINISH	EW Aviation, Inc.	DWG. NO. 41232-200-001

PROPRIETARY
RIGHTS NOTICE
THESE DATA ARE PROPRIETARY INFORMATION OF ERA AVIATION, INC.
DISCLOSURE, REPRODUCTION,
OR USE WITHOUT THE WRITTEN AUTHORIZATION FROM
ERA AVIATION, INC., THE OWNER OF THE DATA,
IS PROHIBITED.
NOT APPLICABLE TO VENDOR PARTS.

002-001
DRAFTSMAN D. NELSON 5/20/02
CHECK D. MURPHY 5/20/02
STRESS
PROF ENGR
HEAT TREAT
FINISH

UNLESS OTHERWISE SPECIFIED
X±.1
XX±.03
XXX±.010
ANGLES
±.1/2"

NEXT ASSEMBLY

REV. IR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries